

Date: Thursday, 27/11/2008 2:37:40 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R44 BEARPAW
Job Number	: 43830		
Estimate Number	: 10100		
P.O. Number	:	Part Number	: D30751
This Issue	: 27/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3075 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 35754A	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 04/12/2008
Checked & Approved By	: <u>JLD 08-11-27</u>	Qty:	2 Um: Each
Comment	: Est Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM Est Rev:D Added C'Bores as per Rev B 07-03-28 JLM Est Rev:E 08-01-09 Added Step 2 JLM Verified By:EC Est Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING
 Program Batch Number

JLD 08-11-27

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 1.0000 sf(s)/Unit Total: 2.0000 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: 109186 B 8-10-2

(2)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



B 8-10-2



Comment: FLOW WATER JET
 CUT BLANK AS PER FILE D3075-1_BLANK

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

JLD 08/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:37:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 43830

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11(2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

34 44703

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 JF

Job Completion



MF 09-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43830
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

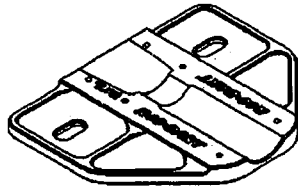
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.06 x 45°	✓			
B	0.63	+/-0.030	.635	✓			
C	0.250	+/-0.010	.255	✓			
D	0.950	+0.030/-0.010	.950	✓			
E	5.50	+/-0.030	5.502	✓			
F	0.25 x 45°	+/-0.030	.260 x 45°	✓			
G	0.900	+/-0.010	.890	✓			
H	0.375	+/-0.010	.385	✓			
I	1.30	+/-0.030	1.30	✓			
J	5.70	+/-0.030	5.690	✓			
K	0.37	+/-0.030	.375	✓			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	.260	✓			
N	0.93	+/-0.030	.925	✓			
O	0.30	+0.030/-0.000	.325	✓			
P	1.08	+/-0.030	1.08	✓			
Q	5.870	+/-0.010	5.870	✓			
R	10.14	+/-0.030	10.140	✓			

Measured by:	JL	Audited by:	J.F.	Prototype Approval:	N/A
Date:	09/11/10	Date:	09/01/11	Date:	N/A

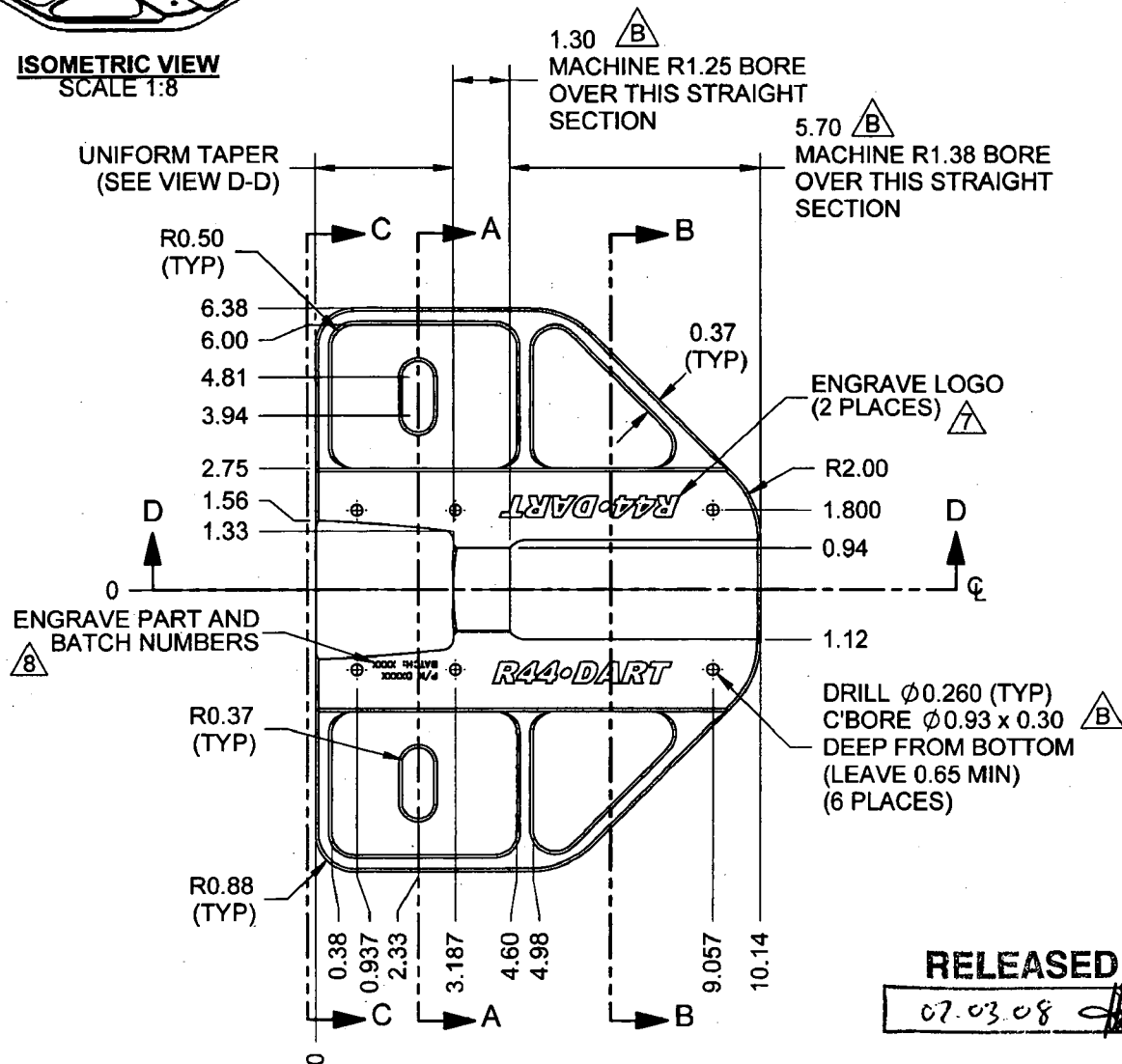
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	

DART

DESIGN <i>[Signature]</i>	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27	TITLE R44 BEARPAW		SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8

**D3075-1 BEARPAW****NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950) PY
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

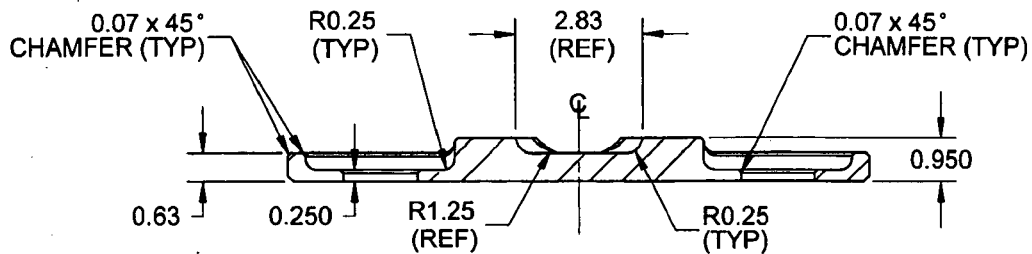
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43830

COPYRIGHT © 2002 BY DART AEROSPACE LTD

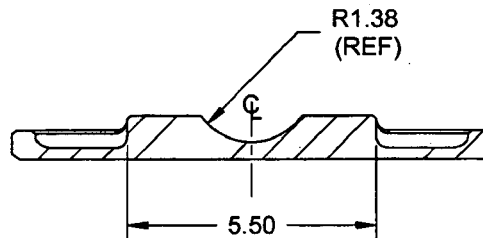
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



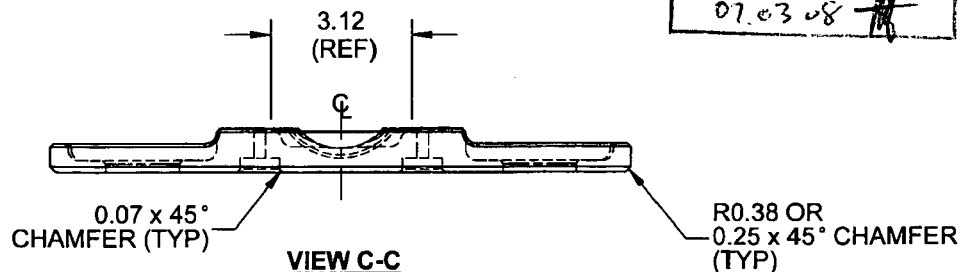
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4



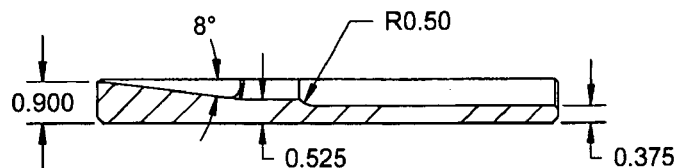
SECTION A-A



SECTION B-B



VIEW C-C



SECTION D-D

RELEASED
07.03.08
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43830

COPYRIGHT © 2002 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.